

Work Order ID 148103

June 24, 2016 11:40:04 AM

148103

*Ship July 5 or
sooner.*

Page 1

Item ID: D206-802-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Passenger Door Opener LH

Stop

NS2

Start Date: 6/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SA Date: 6/24/16

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

Date:

SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-3	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-031 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

SA 6/24/16

JUN 27 2016

DAS 26 9-89
DAS 27 9-89

DAS 26 9-89

JUL 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		FAULT CATEGORY OTHER : ☐							

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Item ID: D206-802-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Passenger Door Opener LH

Start Date: 6/27/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-031								
	Location:								
	PPP rev: <u>148101</u>								
130		0.00							
130	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

JUL 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : _____							

Picklist Print

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Work Order ID: 148103

148103

Parent Item: D206-802-031

D206-802-031

Parent Item Name: Passenger Door Opener LH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17 *D3552-17* Door Prop		Manufactured	No			105	Each	3.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST363		3							
				126847		3							
D3622-5 *D3622-5* Ball Stud		Manufactured	No			105	Each	8.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST046		8							
				129766		4							
				133920		4							
D4115-5 *D4115-5* Doubler		Manufactured	No			105	Each	1.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST084		1							
				129975		1							
D4115-041 *D4115-041* Litter Door Bracket Assembly		Manufactured	No			105	Each	0.0000	1	1		DAS 6 9-89	DAS 27 9-89
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					

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Work Order ID: 148103

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Parent Item: D206-802-031

D206-802-031

Parent Item Name: Passenger Door Opener LH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

CR3242-5-4 Purchased No

105 Each 69.0000 3 3

CR3242-5-4

Rivet

**

DAS 6 27
9-89 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST317

69

116583

69

3

CR3243-5-4 Purchased No

105 Each 64.0000 2 2

CR3243-5-4

Rivet

**

DAS 6 27
9-89 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST317

64

116583

64

2

MS20426AD4-5 Purchased No

105 Each 1,666.000 2 2

MS20426AD4-5

RIVET

**

DAS 6 27
9-89 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

1316

m133751

1316

ST312

350

m133751

350

2

MS20600-AD4W2 Purchased No

105 Each 369.0000 9 9

MS20600-AD4W2

Rivet

**

DAS 6 27
9-89 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

119

m126475

119

ST308

250

m134762

150

m135058

100

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Work Order ID: 148103

148103

Parent Item: D206-802-031

D206-802-031

Parent Item Name: Passenger Door Opener LH

Start Date: 6/27/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

59.0000

1

1

MS21073L5

Anchor Nut

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST298

59

m132680

9

m135058

50

NAS1149C0532R

Purchased

No

105

Each

483.0000

3

3

NAS1149C0532R

WASHER

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

60

116513

60

ST266

423

m133031

23

m134756

200

m135056

200

NAS1149C0563R

Purchased

No

105

Each

467.0000

3

3

NAS1149C0563R

Washer

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

467

m131697

467

DAS
28
9-89

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5.0 PARTS LIST

5.1 D206-802-029/-030 Crew Door Opener Kits

DAS
28
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Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER